

Thursday, 01/21/2007 2:28:41 PM  
 Jim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)  
 Job Number : 33043  
 Estimate Number : 10534  
 P.O. Number : N/A Part Number : D2574  
 This Issue : 6/21/2007 S.O. No. : N/A Drawing Number : D2574 REV E  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : E  
 Previous Run : 32168 Material : N/A Due Date : 7/11/2007 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: I As Per RevE 06-01-27 JLM

Additional Product:

Part Number:



Seq. #:

Machine Or Operation:

Description:

10

D6101005

7075-T7351 8.25X5.0X2.5



Comment: Qty: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: B25330

20

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. SA Double check by: JF

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

30

MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 &amp; D2574

40

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 33043

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J-F

07/07/17

(14)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SL

07-07-17

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN SANDTEX (Ref: 4.3.5.1) as per QSI 005 4.3

white M 101575

M-H/BL

07-07-17<sup>2</sup>

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

07/07/17

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57433

07/7/17

(2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.18

Completion



u 07.07.18





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 33043
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.439	0.440	0.439	0.438		
B	1.745	1.755		1.751	1.750	1.750	1.749		
C	3.495	3.505		3.500	3.501	3.500	3.499		
D	1.745	1.755		1.750	1.750	1.750	1.749		
E	7.990	8.010		8.001	8.002	8.001	7.999		
F	0.490	0.510		.496	0.504	0.504	0.502		
G	0.257	0.262	DT8683	.257	0.258	0.258	0.258		
H	0.375	0.380	DT8684	.376	0.377	0.377	0.377		
I	0.490	0.510		.501	0.500	0.501	0.500		
J	1.174	1.184		1.171	1.178	1.178	1.178		
K	0.558	0.578		.571	0.571	0.571	0.568		
L	1.174	1.184		1.172	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.369	1.369	1.369		
N	2.495	2.505		2.495	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.121	4.121	4.122		
P	0.115	0.135		.124	0.124	0.125	0.124		
Q	0.115	0.135		.135	0.135	0.135	0.135		
R	0.240	0.260		.250	0.250	0.251	0.251		
S	0.115	0.135		.130	0.132	0.134	0.134		
T	0.178	0.198		.183	0.188	0.188	0.188		
U	3.210	3.250		3.232	3.231	3.231	3.230		
V	0.230	0.250		.241	0.246	0.246	0.241		
W	0.115	0.135		.135	0.131	0.134	0.134		
X	0.307	0.312		.310	0.311	0.310	0.310		
Y	0.760	0.765		.762	0.766	0.766	0.766		
Z	0.352	0.372		.370	0.369	0.369	0.369		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		.629	0.630	0.629	0.629		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.249	0.246	0.246	0.247		
AE	1.500	1.520		1.511	1.511	1.511	1.509		
AF	0.115	0.135		.135	0.135	0.135	0.135		
AG	0.240	0.280		.270	0.270	0.270	0.270		
AH	0.240	0.260		.250	0.250	0.249	0.251		
AI	2.000	2.020		2.002	2.002	2.003	2.001		
AJ	0.023	0.043		.051	0.033	0.033	0.033		
Accept/Reject									

Measured by: SN/ J.K.	Audited by: J.F.
Date: 07/07/13	Date: 07/27/16

Measured by: SN/ J.K.	Audited by: J.F.
Date: 07/07/13	Date: 07/27/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 33043
Description: Saddle, Aft Inboard		<b>Part Number:</b> D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.003	8.003		
F	0.490	0.510		0.500	0.499	0.498	0.500		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.564	0.563	0.563	0.562		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.369	1.370	1.370	1.370		
N	2.495	2.505		2.506	2.506	2.502	2.501		
O	4.119	4.129		4.121	4.121	4.122	4.123		
P	0.115	0.135		0.123	0.124	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.251	0.252	0.251		
S	0.115	0.135		0.129	0.129	0.122	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.236	3.230	3.232	3.232		
V	0.230	0.250		0.238	0.239	0.238	0.240		
W	0.115	0.135		0.125	0.130	0.127	0.130		
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372		0.368	0.368	0.367	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.630	0.632	0.633	0.634		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.247	0.247	0.250		
AE	1.500	1.520		1.511	1.511	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.270	0.265	0.266	0.269		
AH	0.240	0.260		0.250	0.249	0.251	0.249		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		0.033					
Accept/Reject									

Measured by: [Signature]
Date: 07/07/16

Audited by: JF
Date: 07/07/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]





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B	1.745	1.755		1.745	1.744	1.745	1.744		
C	3.495	3.505		3.495	3.494	3.495	3.494		
D	1.745	1.755		1.745	1.744	1.745	1.744		
E	7.990	8.010		7.990	8.002	7.990	8.000		
F	0.490	0.510		.497	.496	.497	.496		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.496	.502	.503	.503		
J	1.174	1.184		1.175	1.175	1.175	1.175		
K	0.558	0.578		.572	.572	.573	.572		
L	1.174	1.184		1.175	1.175	1.175	1.175		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.497	2.498	2.497	2.499		
O	4.119	4.129		4.125	4.127	4.127	4.127		
P	0.115	0.135		.123	.124	.124	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.245	.251	.245	.249		
S	0.115	0.135		.122	.123	.123	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.241	.252	.252	.24		
W	0.115	0.135		.123	.126	.127	.127		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.762	.763	.763	.763		
Z	0.352	0.372		.367	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.630	.628	.627		
AC	0.053	0.073		.065	.063	.063	.063		
AD	0.240	0.260		.250	.248	.251	.250		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.133	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.245	.253	.250	.250		
AI	2.000	2.020		2.001	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SD
Date:	07.07.16

Audited by:	J.F
Date:	07/07/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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DART AEROSPACE LTD		Work Order:	33043
Description: Saddle, Aft Inboard		Part Number:	D2574
Revision Dwg: D2574 Rev. E		Page 1 of 1	

Indicate dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below.

			Recorded Actual Dimensions				By	Date
Min	Max	Go/No Go Gauge	1	2	3	4		
0.438	0.443	<del>0.440</del>	.435	.435				
1.755	1.755		1.750	1.750				
3.505	3.505		3.500	3.500				
1.755	1.755		1.750	1.750				
8.010	8.010		8.003	8.003				
0.490	0.510		.496	.495				
0.250	0.250		.238	.238				
0.330	0.330		.376	.376				
0.510	0.510		.501	.503				
1.134	1.134		1.171	1.171				
0.575	0.575		.573	.573				
1.134	1.134		1.171	1.171				
1.375	1.375		1.370	1.370				
2.505	2.505		2.498	2.498				
4.125	4.125		4.124	4.124				
0.135	0.135		.124	.124				
0.135	0.135		.135	.135				
0.250	0.250		.250	.251				
0.135	0.135		.124	.124				
0.135	0.135		.188	.188				
3.230	3.230		3.232	3.232				
0.250	0.250		.242	.242				
0.135	0.135		.128	.127				
0.310	0.310		.310	.310				
0.765	0.765		.763	.763				
0.375	0.375		.364	.363				
0.530	0.530		.500	.500				
0.635	0.635		.627	.625				
0.075	0.075		.063	.063				
0.250	0.250		.251	.251				
1.520	1.520		1.511	1.511				
0.135	0.135		.135	.135				
0.230	0.230		.260	.260				
0.260	0.260		.251	.251				
2.020	2.020		2.001	2.002				
0.043	0.043		.033	.033				

Accept/Reject

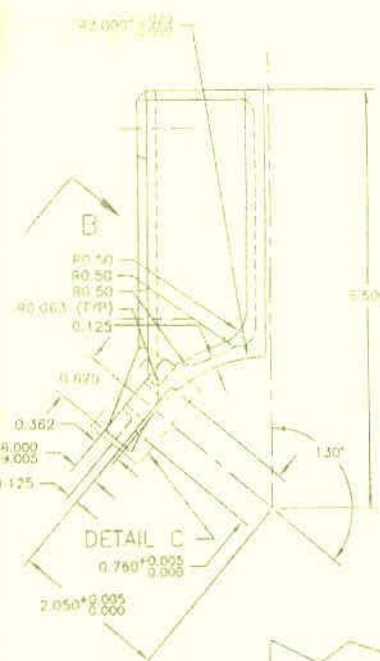
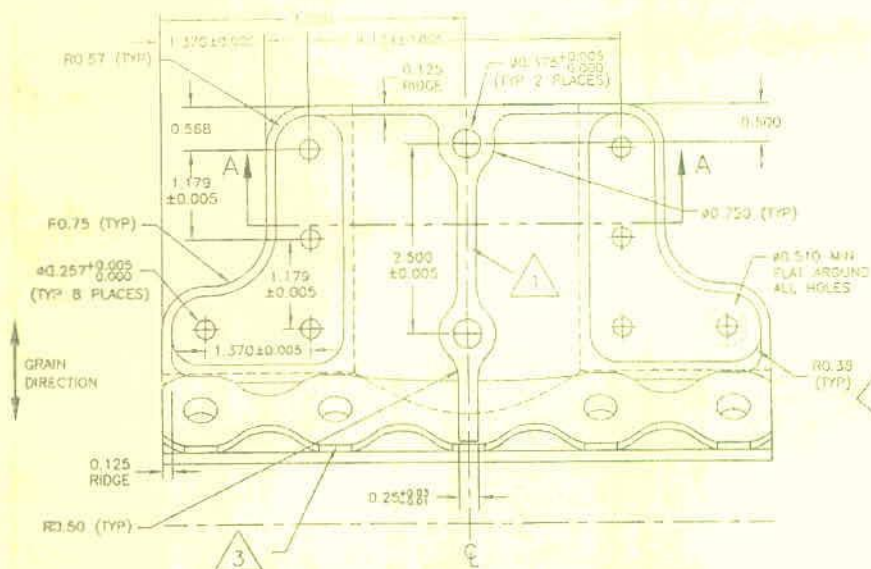
Inspected by: <i>JD</i>	Audited by: <i>J.F.</i>
Date: 07.07.16	Date: 07/07/16

Date	Change	Revised by	Approved
	New Issue	RF	
02.02.17	Re-format, Added Rev. D	KJ	
02.10.11	Re-format, Added DT8682, DT8683, DT8684	KJ	
03.05.05	Added dimension AI	KJ/RF	
06.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>





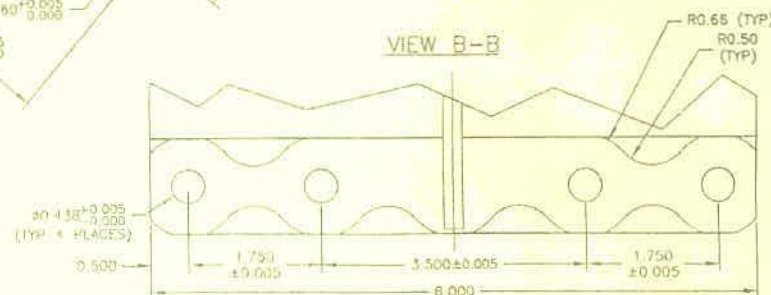
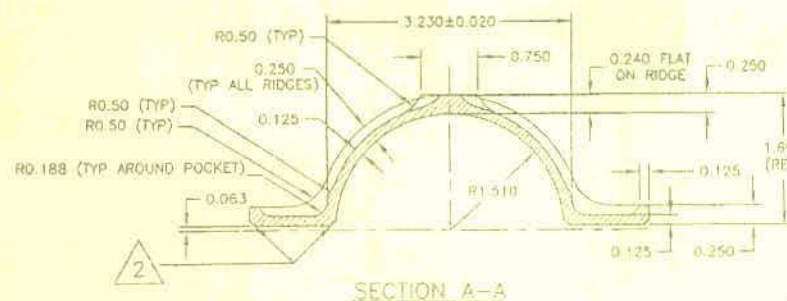
05 1-06 H






## NOTES

MATERIAL 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALUMINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
| 3 | CHAMFER 0.063 x 45° ALL AROUND                                   |
| 4 | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES, TIGHTEN TOLERANCES
C	99.10.22	INCRP DES 9123/9079/9102 ADD DIMENSIONS PER TSR 41177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		DRAWN BY
DS	PH	
DART AEROSPACE LTD.		PORTHURST, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		02574
DATE	TITLE	
05.07.15	INNER AFT SADDLE	

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GALT ASSOCIATES LTD.

**DART**

**DART AEROSPACE LTD.**  
MISSISSAUGA, ONTARIO, CANADA

MSX-1

SHEET 1 OF 1

SCALE

20

